

Date: Tuesday, 07/04/2009 11:17:08 AM
 User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D350-636-011
Job Number : 47031	
Estimate Number : 10804	
P.O. Number :	Part Number : D350636011
This Issue : 07/04/2009 S.O. No. :	Drawing Number : R09-017
Prsht Rev. : NC	Project Number :
First Issue : // Type : SKIDTUBES	Drawing Revision :
Previous Run : 00015	Material :
Written By : <i>[Signature]</i>	Due Date : 14/04/2009 Qty: 1 Um: Each
Checked & Approved By : <i>JL 09.04.07</i>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D350636011	Skidtube LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Skidtube LH
 Original B43783 @ CHG004

2.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Tube has minor surface scratches, from trail assemblies and will need to be sanded and re-powder coated.

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Dis-assemble the entire tube, and keep all hardware

✓ ***See attached of original reference copy***

✓ Identify all hardware as to which work order it belongs to for traceability.

- Wash and remove all LPS product applied to the tube. Interior and exterior, and on the hardware.

✓ Scuff entire tube, with a 320 grit paper for re-powder coating per QSI005.

✓ Strip entire tube - touch-up with stodine.

AWM 9-4-16

JL 09-04-13 XL

4.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Pressure Wash

UMD/FX

09/05/04

Powder coat the entire tube white per QSI005 M *109996*

Start time: *1:10*

Oven Temp: *320°*

Finish time: *1:40*

FX 09/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 11:17:08 AM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-011

Job Number: 47031

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

N/A Re-powder wearpads Grey as necessary per QSI005. M

Start time:

Oven Temp:

Finish time:

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-05

(XV)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Re-assemble tubes using existing stock.

If some hardware is replaced record below:

AN9606-106/M111276 Qty 38

M521083-C8/M110584 Qty 1

AL541032225/M110118 Qty 38

D3794-1/1347212 Qty 1

D3794-3/1346531 Qty 1

D3536-25/1345569 Qty 1

Qty

Qty

Qty

14

09-05-05

(XV)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M111013

EXP DATE: 10/20

3- assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M101223

4- Coat all exposed fasteners with "LPS Procyon"

batch: M104251

14

09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 11:17:08 AM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-011

Job Number: 47031

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ensure approval e-mail is attached for the removal of LPS 3 on the inside of the tube.

809105/05

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

New labels and paperwork are required with the new batch #

500 09-04-07 ①

10.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 45320

88 09105/05

11.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M110341

*****apply antiseize prior to packaging*****

Batch: M110658

88 09105/05

12.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M116139

88 09105/05

13.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

88 09105/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 11:17:08 AM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-011

Job Number: 47031

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: _____

M111424

SS 09/05/05 (X)

15.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: _____

44917

SS 09/05/05 (X)

16.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)

batch: _____

44904

SS 09/05/05 (X)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*****ensure antiseize is on AN8C21A bolts*****

S02/05/06 (X)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

CHG004 9/5/06

(10)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07 MF 09-05-07

Job Completion



B47031

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:51:22 PM
User: Juliet Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Job Number : 43783
Estimate Number : 10262
P.O. Number : Part Number : D350636011
This Issue : 26/11/2008 S.O. No. : Drawing Number : D2750 REV F
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : SKIDTUBES Drawing Revision : F
Previous Run : 43782 Material :
Written By : Due Date : 20/12/2008 Qty: 1 Um: Each
Checked & Approved By : JUD 08.11.26
Comment : Est Rev: I 02.09.25 Rearranged procedure steps KJ
Est Rev: J 06-03-23 As per Rev D JLM
Est Rev: K 06-07.13 As per dsi9343 EC
Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM
Verified By: EC
Est Rev: M 08-04-22 update steps 4, 13 DD verified by: EC
Est Rev: N 08-09-23 revF as per dwg DD verified by: ec

REFERENCE ONLY

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



for JUD 08/12/12



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

5 or 6/12/12

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

43495

SL8-11-29

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: *39242*

SL8-11-29

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.

SL8-11-29

Date: Wednesday, 26/11/2008 12:51:22 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 43783

Part Number: D350636011

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: M109817

JH

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1- Install inserts as per Dwg D2750

JH 08-12-18

(X)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

Batch: (1x) B42778 (3x) B43754

(JH)

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B42982

JH

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: B43459

JH

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: ~~B43459~~ B43460

JH

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: B43147

JH

08-12-18

(X)

Date: Wednesday, 26/11/2008 12:51:22 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 43783

Part Number: D350636011

Job Number:



REFERENCE ONLY

Seq. #: Machine Or Operation: Description :

26.0 D37943 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: B42486

JK

27.0 D353525 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B43405

JK

28.0 D353625 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B448454

JK

29.0 D35371 Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

WEARPAD

Batch: B43346

JK

30.0 D36311 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: B41141

JK

31.0 D3488041 Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, LH

Batch: B41206

JK

32.0 NAS1611010 O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

O-RING

NAS1611-010 batch: M109962

(or MS28775-010) batch:

* JK

08.12.15

Date: Wednesday, 26/11/2008 12:51:22 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 43783

Part Number: D350636011

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	NAS1611013	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: M106513

ju

34.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B344343

ju

35.0	D3492043	Plug Assembly
------	----------	---------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B342997

ju

36.0	AN3C5A	Bolt
------	--------	------



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M110002

ju

37.0	AN3C6A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M108880

ju

38.0	AN6C44A	BOLT
------	---------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M110105

ju

39.0	AN8C35A	BOLT
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M110105

ju

08-12-18

(ju)

Date: Wednesday, 26/11/2008 12:51:22 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 43783

Part Number: D350636011

Job Number:



REFERENCE ONLY

Seq. #: 40.0

Machine Or Operation: AN960C10L

Description: washer



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

washer

Batch: M109798

JU

X

41.0

AN960C816L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WASHER

Batch: M110139

JU

42.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M170002

JU

43.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M1109740

JU

44.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: M1106516

JU

45.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: M1109539

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 104883

EXP DATE: 09/11

JU 08.12.18 (X)

Date: Wednesday, 26/11/2008 12:51:22 PM
User: Julie Dawson

Process Sheet

Est # 10262

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

chy

Job Number: 43783

Part Number: D350636011

Job Number:



REFERENCE ONLY

Seq. #:

- Machine Or Operation:

Description:

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M101223

5-Coat all exposed fasteners with "LPS Procyon" batch: M104251

08-18-12 26

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/10/15 (40)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade

Batch: 43258 ?

49.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M109772

50.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M110135

51.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M108564

12/04/16 (1)



Seq. #:

Machine Or Operation:

Description :

52.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch:

M10372

M110372

REFERENCE ONLY

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch:

43453

54.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)

batch:

42350

C9/01/15 (13)

55.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 02/01/19 (40)

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

Koe 70

RWC 9/1/19

(17)

SP

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/2019

Job Completion



B43783

U 09.01.20

DART

TRANSPORT CANADA APPROVAL # 09-89

TEL : 1-613-632-3336
FAX: 1-613-632-4443

P/N	D350-636-011	CHG	CHG004
DESC	Skidtube LH	STC	SH99-7
LOT	B43783	STC	SR00646SE
MODEL	AS350/355	STC	

JS PATENT # 5735484
CANADA FOREIGN PATENTS PENDING

MADE IN CANADA

Date: Tuesday, 05/05/2009 9:22:31 AM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43783	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10262	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636011
Complete Date	: 20/01/2009 12:36:06	DWG Number	: D2750 REV F
		Rev.	: F

DUE DATE	ORDERED	DELIVERED
20/12/2008	1	1

2.0 D26003BENT-Extrusion Bent		INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty		COST	
20/01/2009	LACE01: Lacelle, Linda	D26003BENT	1.000		\$41.82	Lot # 43495 Qty. 1
Subtotal:		QTD: 1	CTD: 0		\$41.82	

3.0 D2744-Cap INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
20/01/2009	LACE01: Lacelle, Linda	D2744	1.000		\$1.04	Lot # 39242 Qty. 1
Subtotal:		QTD: 1	CTD: 0		\$1.04	

4.0 SKIDTUBES 1 Internal Operation								
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
29/11/2008	LEVI01: Levis, Sylvain	Run	1.000	1.20	\$22.79	1.20	51.05	
01/12/2008	ELLI01: Elliott, Barclay	Run	0.000	0.41	\$7.79	0.41	17.45	
01/12/2008	TITL01: Titley, Ian	Run	1.000	0.41	\$6.63	0.41	14.85	
01/12/2008	TITL01: Titley, Ian	Run	1.000	0.74	\$11.96	0.74	26.79	
Subtotal:		QTD: 3 CTD:	0	2.76	\$159.31			

7.0 HAND FINISHING1 Internal Operation								
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
01/12/2008	TITL01: Tittley, Ian	Run	1.000	0.16	\$2.59	0.64	25.13	
Subtotal:		QTD: 1	CTD: 0	0.16	\$27.72			

9.0 D2739-350 / Beam INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
20/01/2009	LACE01: Lacelle, Linda	D2739	1.000		\$53.97	Lot # 43836 Qty. 1
Subtotal:		QTD: 1	CTD: 0		\$53.97	

10.0 D34901-Cross Bolt Spacer		INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	ELLI01: Elliott, Barclay	D34901	4.000		\$10.15	Lot # 43013 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$10.15

11.0 D34903-Cross Bolt Spacer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	ELLI01: Elliott, Barclay	D34903	4.000		\$56.90	Lot # 43014 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$56.90

12.0 D2743-Crossbolt Spacer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	ELLI01: Elliott, Barclay	D2743	8.000		\$24.08	Lot # 42777 Qty. 8
Subtotal:		QTD:	0	CTD:	8	\$24.08

REFERENCE ONLY

Date: Tuesday, 05/05/2009 9:22:31 AM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43783	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10262	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636011
Complete Date	: 20/01/2009 12:36:06	DWG Number	: D2750 REV F
		Rev.	: F

13.0 SKIDTUBES 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
02/12/2008	TITL01: Titley, Ian	Run	1.000	0.87	\$14.06	0.87	31.49
03/12/2008	TITL01: Titley, Ian	Run	1.000	0.25	\$4.04	0.25	9.05
05/12/2008	ELLI01: Elliott, Barclay	Run	0.000	0.41	\$7.79	0.41	17.45
08/12/2008	ELLI01: Elliott, Barclay	Run	0.000	0.19	\$3.61	0.19	8.09
08/12/2008	ELLI01: Elliott, Barclay	Run	0.000	1.63	\$30.95	1.63	69.33
08/12/2008	MAHE01: Maheu, Andrew	Run	0.000	0.27	\$4.36	0.27	9.77
08/12/2008	MAHE01: Maheu, Andrew	Run	1.000	0.40	\$6.46	0.40	14.47
09/12/2008	MAHE01: Maheu, Andrew	Run	1.000	1.06	\$17.13	1.06	38.37
09/12/2008	ELLI01: Elliott, Barclay	Run	0.000	0.31	\$5.89	0.31	13.19
10/12/2008	ELLI01: Elliott, Barclay	Run	311.000	0.38	\$7.22	0.38	16.17
Subtotal:			QTD:	315 CTD:	0	5.77	\$328.89

16.0 HAND FINISHING1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
11/12/2008	GREG01: Gregory, Marc	Run	1.000	0.45	\$7.00	1.66	62.72
Subtotal:			QTD:	1 CTD:	0	0.45	\$69.72

17.0 POWDER COATING Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
11/12/2008	GREG01: Gregory, Marc	Run	0.000	0.09	\$1.40	0.27	10.21
11/12/2008	GREG01: Gregory, Marc	Run	1.000	0.14	\$2.18	0.53	20.02
Subtotal:			QTD:	1 CTD:	0	0.23	\$33.81

19.0 ALS41032225-Insert INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	ALS41032225	38.000	\$6.39	Lot # 109817 Qty. 38
Subtotal:			QTD:	0 CTD:	38 \$6.39

21.0 D2745-Bushing INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	D2745	1.000	\$5.40	Lot # 42778 Qty. 1
15/01/2009	LAUG01: Laughren, Gary	D2745	7.000	\$37.79	Lot # 43754 Qty. 7
Subtotal:			QTD:	0 CTD:	8 \$43.19

22.0 D37911-Wearplate INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	D37911	1.000	\$24.83	Lot # 42982 Qty. 1
Subtotal:			QTD:	0 CTD:	1 \$24.83

23.0 D37931-Wearshoe INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	D37931	1.000	\$22.25	Lot # 43459 Qty. 1
Subtotal:			QTD:	0 CTD:	1 \$22.25

Date: Tuesday, 05/05/2009 9:22:31 AM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43783	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10262	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636011
Complete Date	: 20/01/2009 12:36:06	DWG Number	: D2750 REV F
		Rev.	: F

24.0 D37933-Wearshoe INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/01/2009	LAUG01: Laughren, Gary	D37933	1.000		\$19.06	Lot # 43460 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$19.06

25.0 D37941-Gasket INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/01/2009	LAUG01: Laughren, Gary	D37941	1.000		\$5.34	Lot # 43147 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$5.34

26.0 D37943-Gasket INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/01/2009	LAUG01: Laughren, Gary	D37943	1.000		\$3.03	Lot # 42486 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$3.03

27.0 D353525-Wearshoe INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/01/2009	LAUG01: Laughren, Gary	D353525	1.000		\$18.62	Lot # 43405 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$18.62

28.0 D353625-Gasket INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/01/2009	LAUG01: Laughren, Gary	D353625	1.000		\$4.51	Lot # 43454 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$4.51

29.0 D35371-Wearpad INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/01/2009	LAUG01: Laughren, Gary	D35371	3.000		\$84.34	Lot # 43346 Qty. 3
Subtotal:		QTD:	0	CTD:	3	\$84.34

30.0 D36311-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/01/2009	LAUG01: Laughren, Gary	D36311	8.000		\$0.56	Lot # 41141 Qty. 8
Subtotal:		QTD:	0	CTD:	8	\$0.56

31.0 D3488041-Blade Fitting Assembly, LH INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/01/2009	LAUG01: Laughren, Gary	D3488041	1.000		\$187.77	Lot # 41206 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$187.77

32.0 NAS1611010-O-RING INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
20/01/2009	LACE01: Lacelle, Linda	NAS1611010	1.000		\$0.65	Lot # 109962 Qty. 1
Subtotal:		QTD:	1	CTD:	0	\$0.65

REFERENCE ONLY

Date: Tuesday, 05/05/2009 9:22:32 AM
 User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43783	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10262	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636011
Complete Date	: 20/01/2009 12:36:06	DWG Number	: D2750 REV F
		Rev.	: F

33.0 NAS1611013-O-RING INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	NAS1611013	1.000	\$0.51	Lot # 106513 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$0.51					

34.0 D3492041-Plug Assembly INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	D3492041	8.000	\$23.89	Lot # 44343 Qty. 8
Subtotal: QTD: 0 CTD: 8 \$23.89					

35.0 D3492043-Plug Assembly INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	D3492043	8.000	\$24.81	Lot # 42997 Qty. 8
Subtotal: QTD: 0 CTD: 8 \$24.81					

36.0 AN3C5A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	AN3C5A	34.000	\$14.45	Lot # 110002 Qty. 34
Subtotal: QTD: 0 CTD: 34 \$14.45					

37.0 AN3C6A-BOLT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	AN3C6A	4.000	\$2.15	Lot # 108880 Qty. 4
Subtotal: QTD: 0 CTD: 4 \$2.15					

38.0 AN6C44A-BOLT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	AN6C44A	4.000	\$112.17	Lot # 110105 Qty. 4
Subtotal: QTD: 0 CTD: 4 \$112.17					

39.0 AN8C35A-BOLT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	AN8C35A	1.000	\$64.09	Lot # 110105 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$64.09					

41.0 AN960C816L-WASHER INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	AN960C816L	1.000	\$0.22	Lot # 110139 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$0.22					

42.0 MS210436-NUT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/01/2009	LAUG01: Laughren, Gary	MS210436	4.000	\$10.22	Lot # 110002 Qty. 4
Subtotal: QTD: 0 CTD: 4 \$10.22					

REFERENCE ONLY

Date: Tuesday, 05/05/2009 9:22:32 AM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43783	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10262	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636011
Complete Date	: 20/01/2009 12:36:06	DWG Number	: D2750 REV F
Rev. : F			

43.0 MS21083C8-NUT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
15/01/2009	LAUG01: Laughren, Gary	MS21083C8	1.000		\$1.90		Lot # 109740 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$1.90	

44.0 NAS1515H3L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
15/01/2009	LAUG01: Laughren, Gary	NAS1515H3L	4.000		\$0.50		Lot # 106516 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$0.50	

45.0 HAND FINISHING1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
18/12/2008	LAUG01: Laughren, Gary	Run	0.000	2.71	\$42.14	2.71	102.40
15/01/2009	LAUG01: Laughren, Gary	Run	1.000	0.62	\$9.64	0.62	23.43
Subtotal:		QTD:	1	CTD:	0	3.33	\$177.61

48.0 D2741-Blade, 350 Skidtube INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
19/01/2009	DESJ02: Desjardins, Line	D2741	1.000		\$88.36		Lot # 43255 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$88.36	

49.0 AN8C21A-BOLT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
19/01/2009	DESJ02: Desjardins, Line	AN8C21A	2.000		\$56.75		Lot # 109772 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$56.75	

50.0 AN960C816L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
19/01/2009	DESJ02: Desjardins, Line	AN960C816L	2.000		\$0.45		Lot # 110139 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$0.45	

51.0 NAS1515H8L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
19/01/2009	DESJ02: Desjardins, Line	NAS1515H8L	2.000		\$0.40		Lot # 108964 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$0.40	

52.0 MS21083C8-NUT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
19/01/2009	DESJ02: Desjardins, Line	MS21083C8	2.000		\$3.81		Lot # 110372 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$3.81	

53.0 D34931-Washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
19/01/2009	DESJ02: Desjardins, Line	D34931	2.000		\$12.74		Lot # 43453 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$12.74	

REFERENCE ONLY

Date: Tuesday, 05/05/2009 9:22:32 AM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43783	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10262	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636011
Complete Date	: 20/01/2009 12:36:06	DWG Number	: D2750 REV F
		Rev.	: F

54.0 D35321-Spacer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
19/01/2009	DESJ02: Desjardins, Line	D35321	2.000	\$7.29	Lot # 42350 Qty. 2

Subtotal: QTD: 0 CTD: 2 \$7.29

		TIME	COST
	Machine Time:	14.96	\$581.43
	Labor:	12.70	\$215.63
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$1033.21
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$1830.27

COST PER UNIT: \$1830.27

REFERENCE ONLY

1000

Scrapped Parts:

Part No:	batch NO:	QTY:
AN960C-10L	? no number	38
MS21083-C8	M109740	1
ALS 410 2225	M109817	38
D3794-1	1343147	1
D3794-3	1342486	1
D3536-25	1343454	1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries